

Date: Monday, 02/02/2009 1:07:56 PM
 User: Julie Dawson

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3602-1
Job Number	: 45421		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D36021
This Issue	: 02/02/2009 S.O. No. :	Drawing Number	: NCR09-014
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 09/02/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>NO 09.02.02</u>		
Comment	:		

Additional Product

PRELIMINARY ISSUE
09.02.02

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



09.02.02 (1)



Comment: PACKAGING RESOURCE #1

Pull from stock for re-work pre NCR09-014

2.0 D36021 Angle



09.02.02 (1)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

qty 1 of B44148 pulled from stock

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

From D3602-1 as per eng. preliminary dwg D3602.

Use the white aircraft in eng lab for reference for the radius, and form.

FF 09/02/10 (2)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL 09.02.10

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock
Location: _____

with the new B#

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3602-1 PAR #: _____ Fault Category: Small Pals NCR: Yes No DQA: [Signature] Date: 05.05.10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 05.05.10

NCR: <u>45421</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.03.16	3.0	1 part scrap during rework. was not formed correctly, it has too much of a radius, throwing off the angles. EC: process. WIP	<u>[Signature]</u> 05/04/12	Scrap: destroy & replace. See replacement W/O 46504 for replacement.	<u>[Signature]</u> 02/09/03	<u>[Signature]</u>	<u>[Signature]</u> 05/04/12	<u>[Signature]</u> 05.03.16

NOTE: Date & initial all entries

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Drawing Name: D3602-1

Job Number: 45421

Part Number: D36021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/09/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



9-09-06-23

POSITIVE RECALL
EFFECTIVE 9-02-03

RELEASED *[Signature]* AUTH *[Signature]*
DATE 9-03-06

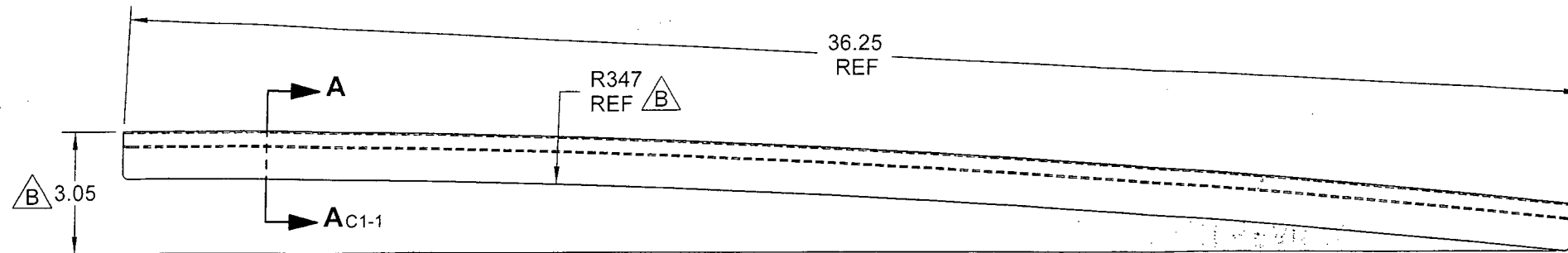
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

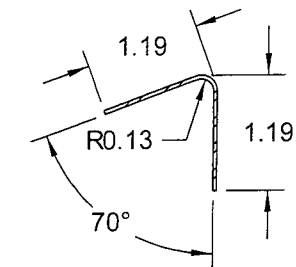
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

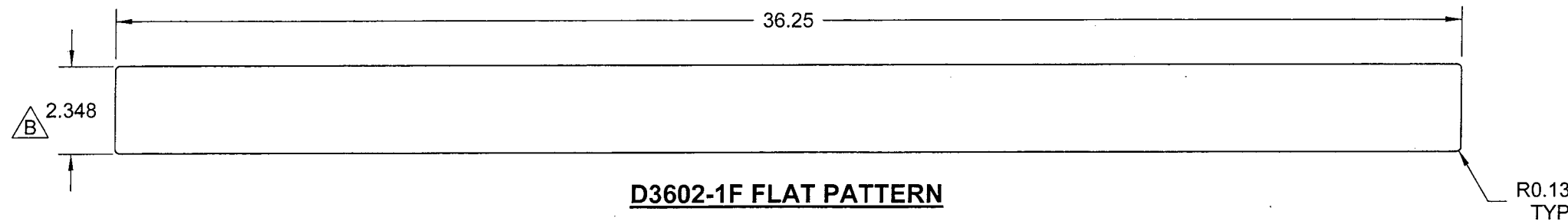
NOTE: Date & initial all entries



D3602-1 ANGLE
(MAKE FROM D3602-1F)



SECTION A-A C7-1
SCALE 2X



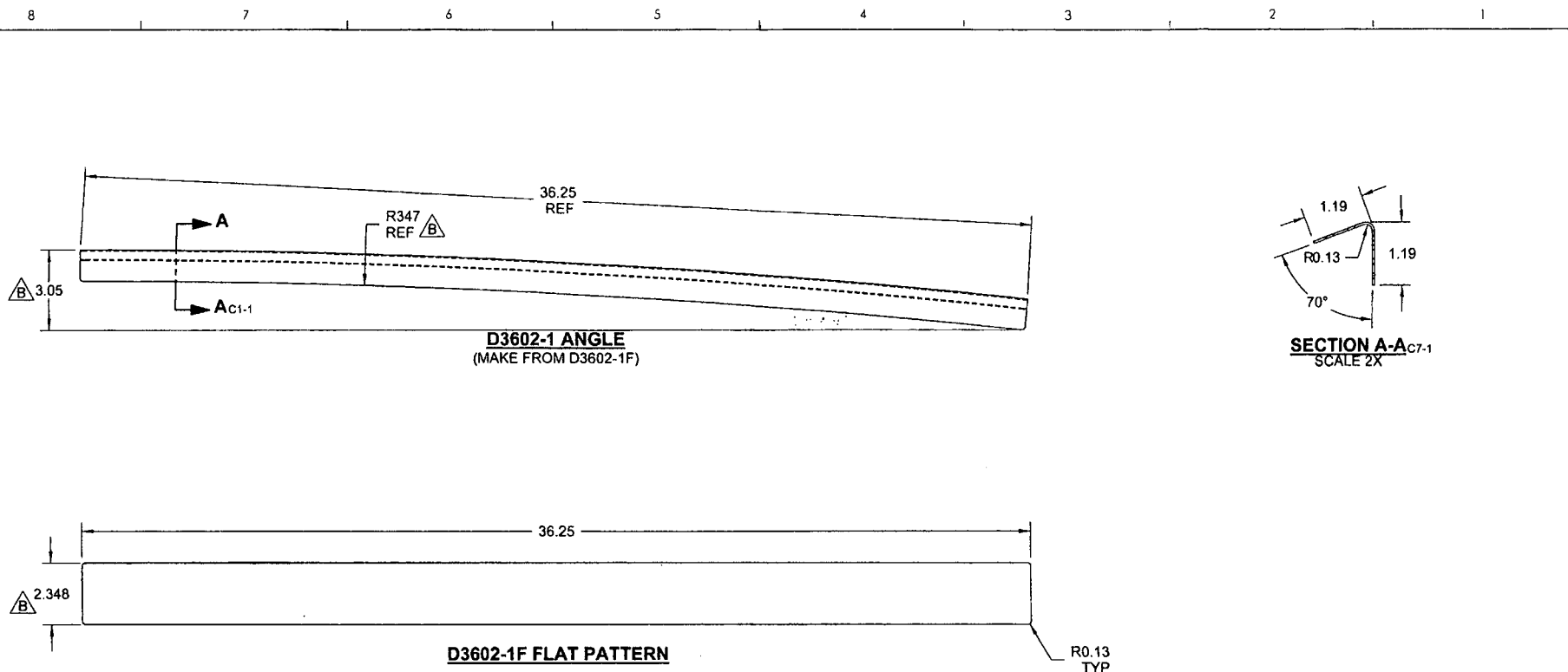
D3602-1F FLAT PATTERN

PRELIMINARY ISSUE

09.02.02 Per ECN # 09-519P

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.97 lbs

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		
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RELEASED
09/03/11

REFERENCE ONLY

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		REV. B	SHEET 1 OF 1
		SCALE	NTS